Work Order ID 74872 *74872* Page 1 October 13, 2011 10:36:59 AM *N900040100* Item ID: D3286-1 Accept Setup Start **Revision ID:** Item Name: Doubler *80* **Start Oty: 80.00 Start Date:** 10/13/11 **Cust Item ID:** Required Date: 10/27/11 Req'd Qty: 80.00 *80* **Customer:** Reference: Run Date: 11 10 114 Tooling: Process Plan: ML J Approvals: Date: Date: SPC (Y/N): Date: Tool # Plan Reject Reject Sequence ID/ Operation Set Up/ Tool ID Accept Insp. Qty Number Stamp Work Center ID Description Code Oty **Run Hours** Draw Nbr **Revision Nbr** D3286 Rev A 100 0.00 FLOW WATER JET *100* B11-10-18 0.00 Waterjet Memo FLOW CNC Waterjet 1-Cut as per Dwg D3286 Dwg Rev: 384.135 Prog Rev: 2-Deburr if necessary BI (-10-0) 110 OC2- Inspect parts off machine FAI/FAIB 0.00 *110* B11-10-19 QC 0.00 Memo Quality Control QC8- Inspect parts - second check 120 OC Memo

Quality Control

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DATE	STEP	Description of NC Section A	-Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Start Date: 10/13/11 Start Qty: 80.00 *80* Cust Item ID: Required Date: 10/27/11 Req'd Qty: 80.00 *80* Customer: Reference: Approvals: Process Plan: Date: Tooling: Date: Stop *Image: QC: Date: SPC (Y/N): Date: *Image: *Imag	
Start Date: 10/13/11 Start Qty: 80.00 *80* Cust Item ID: Required Date: 10/27/11 Req'd Qty: 80.00 *80* Customer: Reference: Approvals: Process Plan: Date: Tooling: Date: Stop *Image: QC: Date: SPC (Y/N): Date: *Image: *Imag	NS1* NS2*
Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: * Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject R	
QC: Date: SPC (Y/N): Date: * Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject	NR1*
	NR2*
Work Center ID Description Run Hours 0.00 *130 *130 NC BRAKE Brake NC Memo Form as per Dwg D3286 Code Qty Qty Numb 0.00 U(())	
QC5- Inspect part completeness to step on W/O 0.00 *140 QC Memo 0.00 Quality Control	17 - 01 (86
Identify as per dwg & Stock Location: *150 Packaging Memo ***STOCK IN SKIDTURE CELL***	//

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Work	Order	ID	74872
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74872

Page 3

October 13, 2011 10:36:59 AM Accept *N900040100* Item ID: D3286-1 Setup Start **Revision ID:** Stop Item Name: Doubler **Start Date:** 10/13/11 **Start Qty: 80.00 Cust Item ID:** Req'd Qty: 80.00 Required Date: 10/27/11 **Customer:** Reference: Run Date: Tooling: **Process Plan:** Date: Approvals: Stop QC: Date: **SPC (Y/N):** Date: Sequence ID/ Tool ID Tool # Plan Reject Reject Insp. Operation Set Up/ Accept Code Qty Qty Number Stamp Work Center ID Description **Run Hours** 160 QC21- Final Inspection - Work Order Release 0.00 *160* 0.00 Memo Quality Control

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W/O:			WO	RK ORDER CHA	NGES					
DATE	STEP	PRO	CEDURE CHAN			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Picklist Print

October 13, 2011 10:37:03 AM

Work Order ID: 74872

74872

Parent Item:

D3286-1

D3286-1

Parent Item Name: Doubler

Start Date: 10/13/11

Required Date: 10/27/11

Page 1

Start Qty: 80.00

Required Qty: 80.00

Comments:

IPP A04.07.14New issueKJ/JLM

Now on Waterjet 06-06-16 JLM IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	134.5600	0.0749	6.307368	٦.		
M304S11	1GA		•						**		13/1-1	8 PC	

304/316 0.125 Sheet

Location	Loc Qty	Loc Code	
MAT020	134.56		
117494	13.06		
119006	57.5		119006
119048	64		



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DART AEROSPACE LTD	Work Order:	74872
Description: Doubler	Part Number:	D3286-1
Inspection Dwg: D3286 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X First Article	Prototype
wing	Actual	Method

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	10.0.0.0.00	Dimension	7.000		Inspection	
5.374	+/-0.010	5,379	2		V 1307	
3.974	+/-0.010	3.979	>		V	
2.000	+/-0.010	100,6	6		V	
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0.125	+/-0.010	117	8		V	
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Measured by:	B	Audited by:	2	Prototype Approval:	N/A
Date:	11-10-19	Date:	4110128	Date:	N/A

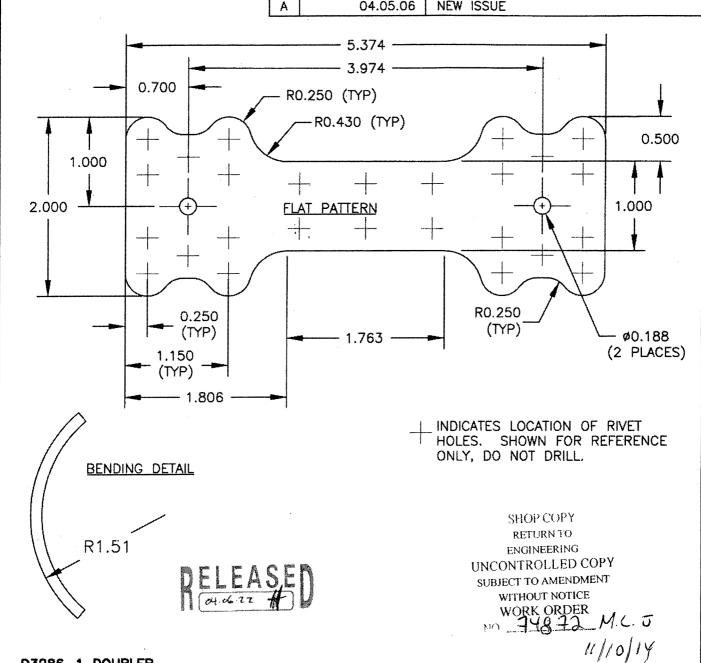
Rev	Date	Change	Revised by	Approved
Α	06.11.07	New Issue	KJ/JLM ox	E

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٨	04.05.06	NEW ICCLIE	



D3286-1 DOUBLER

1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK (REF DART SPEC. M304S11GA)

- BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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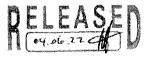
D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL (REF DART SPEC. M304TR0.500W.049)

 2) BREAK ALL SHARP EDGES 0.010 TO 0.020

 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES



Dart Aerospace I	Ltd	
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W/O:			WORK ORDER CHANGES								
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